



Work Order ID 50535

July 14, 2009 1:57:41 PM



Page 1

Item ID: D135-751-011

Accept



Setup

Start



Revision ID: C

Stop



Item Name: Skidtube Installation

Start Date: 7/17/09 Start Qty: 1.00



Cust Item ID:

Required Date: 7/30/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3507

Rev C

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Determine square end of tube and deburr. 2-Drill #30 pilot holes using DT8678. Do not open holes. 3- Deburr holes.

120



BENDING MACHINE - SKIDTUBES

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Initial & initial all entries

Work Order ID 50535



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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Skidtubes

0.00

Skidtubes

Memo

0.00

1-Cut Fwd end of the tube using DT8185
2-Cut Aft end at VC using DT8185
3-Deburr ends
4-Drill Aft & Fwd Cap holes using DT8678
5-Locate DT8870 & Drill Ground wire hole on top of Tube
6-Locate DT8870 with 3/16leco in Ground wire hole, then Pilot Drill a

μ 9-7-16

140



QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

⇒ S 090716

④ f

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

① μ 9-7-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

BE 07/07/09

170



Skidtubes

Skidtubes

0.00

0.00

Skidtubes

Memo

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507.
and Detail "F" 12-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr
and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI
015 A/R 241 Sike Flex Batch: 111557

111557
B-1-31

① 14-7-16

180



QC

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

27 8 07/07/09

(+) f

A/R M111679

BE 9-7-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Initial Date & initial all entries

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Skidtubes

0.00

DE 09/07/20

Skidtubes

Memo

0.00

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.

200



QC5- Inspect part completeness to step on W/O

0.00

=> S 09/07/20 60 ✓

QC

Memo

0.00

Quality Control

210



Pressure Wash per QSI005 4.3

0.00

EL 9-7-22

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powder Coating

Memo

0.00

START TIME:

2:30

OVEN TEMPERATURE:

250

BK 09-07-22 ①

230



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

09-08-05 (K)

240



HandFinishing

0.00

HandFinish

Memo

0.00

Hand Finishing

Install Wearplate &Ground Wire inserts as per Dwg D3507.

BK 0908-5 ①

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250



QC5- Inspect part completeness to step on W/O

0.00

=> Scrollos



QC

Quality Control

Memo

Inspect Inserts

0.00

260



HandFinishing

0.00

Memo

1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And
Detail "A" & "B" ~~10/10/09~~ 241 Sika FlexBatch: W111557 Exp 10/01Date: W111557 3-Install Wearplates as per Dwg D3507 Note:InstBL 09-08-5 ①
BL 09-08-5 ①.

270



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

=> Scrollos



W/O:		WORK ORDER CHANGES					
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Required Date: 7/30/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

280



Packaging

Packaging

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

9/8/11 10 SP

Memo

0.00

290



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

=> Sotolto

10 SP

Memo

0.00

300



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D135-751-011 Location: 88 PPP Rev: B

9/8/11 10 SP

50535

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 7/30/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

310



QC21- Final Inspection - Work Order Release

QC

Quality Control

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

Memo

7/14/09-12
MF 09-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

 Date & initial all entries

Picklist Print

July 14, 2009 2:21:29 PM

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Work Order ID: 50534534



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 7/17/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A		Purchased		No		120	Each	270.0000	8.0000			

BOLT



Warehouse

Location

Main Warehouse

ST

112082

Loc Qty

270

Loc Code

112314 9/18/17 \$0

D2962-150RevA



Manufactured

No

Warehouse

Location

Main Warehouse

ST

28672

Loc Qty

49

Loc Code

B28672 ① 11-7-15

D3504-1RevC



Manufactured

No

Warehouse

Location

Main Warehouse

ST

31234

Loc Qty

31

Loc Code

2 AE 09/07/17

Crossbolt Spacer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 2:21:29 PM

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Work Order ID: 50534 535



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 7/17/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3504-3RevC		Manufactured	No			170	Each	24.0000	1.0000			

Crossbolt Spacer

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

24

31232

24

D3504-5RevC

Manufactured

No

170

Each

26.0000 2.0000

1 BE 09/07/09

Crossbolt Spacer

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

26

36181

26

D3505-1RevA

Manufactured

No

170

Each

2.0000 1.0000

2 BE 09/07/09

Web

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

2

46541

2

50538

2

①

BE 9-7-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50524 535



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 7/17/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3506-1RevA		Manufactured	No			170	Each	6.0000	4.0000			



Doubler

Warehouse

Location

Main Warehouse

FG

Loc Qty

Loc Code

850562 x4 BL 9-7-20

46538

6

6

D3506-3RevA

Manufactured

No



Doubler

Warehouse

Location

Main Warehouse

FG

Loc Qty

Loc Code

850563 x2 BL 9-7-20

28964

8

46539

4

4

ALS7-1032-130

Purchased

No



Insert

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

850563 x2 BL 9-7-20

108606

3914

111529

52

111779

1862

2000

2000

July 14, 2009 2:21:29 PM

1051

Shop Packet Print

38

BL04-08-5.

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID: 50534 535 W



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 7/17/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20601-AD4W3		Purchased	No			240	Each	354.0000	12.0000			

Rivet

Warehouse

Location

Main Warehouse

ST 354

107823 54

111359 300

3
9

BE 09/07/20

ALS4-1032-225

Purchased

No

260

Each

9,190.000 1.0000



Insert

Warehouse

Location

Main Warehouse

ST 9190

107441 28

110768 9162

1

BR 09-08-5.

AN3C4A

Purchased

No

260

Each

270.0000 31.0000



BOLT

Warehouse

Location

Main Warehouse

ST 270

112082 270

31

BR 04-08-5.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 7/30/09

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C1032R10		Purchased	No			260	Each	604.0000	2.0000			

Screw

Warehouse

Location

Main Warehouse

ST	604
108062 ✓	145
108167	35
110049	424

2

BL02-08-5.

AN960C10L



washer

Purchased

No

260

Each

4,964.000 33.0000



Warehouse

Location

Main Warehouse

ST	4964
103585 ✓	100
112116 ✓	4864

33

BL02-08-5.

D2965-3RevB



Manufactured

No

260

Each

6.0000 1.0000



Cap

Warehouse

Location

Main Warehouse

ST	6
46582 ✓	6

1

BL02-08-5.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2965RevB		Manufactured	No			260	Each	29.0000	1.0000			

Cap, 105 Skidtube

Warehouse	Loc Qty	Loc Code	1	BR 04-08-5.
Main Warehouse	50924			
ST	29			
43288	6			
46800	23			
D3492-041RevC	260	Each	27.0000	4.0000

Plug Assembly

Warehouse	Loc Qty	Loc Code	4	BR 04-08-5.
Main Warehouse				
ST	27			
43816	19			
45561	8			
D3492-043RevC	260	Each	0.0000	4.0000

Plug Assembly

34023 48293 4 BR 04-08-5.

W/O:		WORK ORDER CHANGES					
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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3492-047RevC		Manufactured		No		260	Each	66.0000	2.0000			

Plug Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	66	
27776	3	
28961 ✓	45	
39722	18	

2 BL 09-08-5

D3508-1RevC



Manufactured

No

260 Each 6.0000 1.0000



Wearplate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	6	
42973 ✓	6	

1 BL 09-08-5

D3508-3RevC



Manufactured

No

260 Each 7.0000 1.0000



Wearplate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	7	
42250	1	
46881 ✓	6	

1 BL 09-08-5.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50534 535 u



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 7/17/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3508-5RevC		Manufactured	No			260	Each	5.0000	1.0000			

Wearplate

Warehouse

Location

Main Warehouse

ST

42251 ✓

Loc Qty

Loc Code

5

5

D3508-7RevC

Manufactured No



Wearplate

Warehouse

Location

Main Warehouse

ST

44518 ✓

Loc Qty

Loc Code

9

9

D3558-1RevB

Manufactured No



Gasket

Warehouse

Location

Main Warehouse

ST

42533

Loc Qty

Loc Code

4

4

50925

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50994535 W



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 7/17/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3558-3RevB		Manufactured	No		260		Each	12.0000	1.0000			

Gasket

Warehouse

Location

Main Warehouse

ST

45661 ✓

Loc Qty

Loc Code

12

12

1 BR 09-08-5.

D3558-5RevB



Gasket

Manufactured



Warehouse

Location

Main Warehouse

ST

43244 ✓

Loc Qty

Loc Code

5

5

1 BR 09-08-5.

D3558-7RevB



Gasket

Manufactured



Warehouse

Location

Main Warehouse

ST

36388

43245

50927

Loc Qty

Loc Code

11

4

7

1 BR 09-08-5.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50534-535



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 7/17/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1611-007		Purchased	No			260	Each	448.0000	1.0000			
-------------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

O-RING

N
A

used
on Assy/D 3492-041

09-09-21

Warehouse
Location

Main Warehouse

ST 448

103697 448

NAS1611-010

Purchased

No



O-RING

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST 362

110715 67

110915 295

4

BL09-08-5

NAS1611-013

Purchased

No



O-RING

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST 330

106513 11

111424 119

111758 200

N

A

used on
Assy/D 3492-043

mt
09-09-21

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50534 535u



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 7/17/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A		Purchased		No		290	Each	510.0000	2.0000			

Bolt



Warehouse

Location

Main Warehouse

ST 510

111424 ✓
111707 ✓

Loc Qty

Loc Code

2 BR 04-08-5

AN9b0C10L C 09/08/07

AN960JD10L ~~Same as B50534~~ Purchased



Washer



Warehouse

Location

Main Warehouse

ST 7237

101291 16
104885 153
105793 236
109632 ✓ 1832
110985 5000

112116

9/8/7

SP

Main Warehouse

ST182 -84
109632 -84

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50534 535



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 7/17/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3512-1RevC		Manufactured	No			290	Each	5.0000	2.0000			

Wearplate



Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	5	51133
44642	5	91811

~~X~~

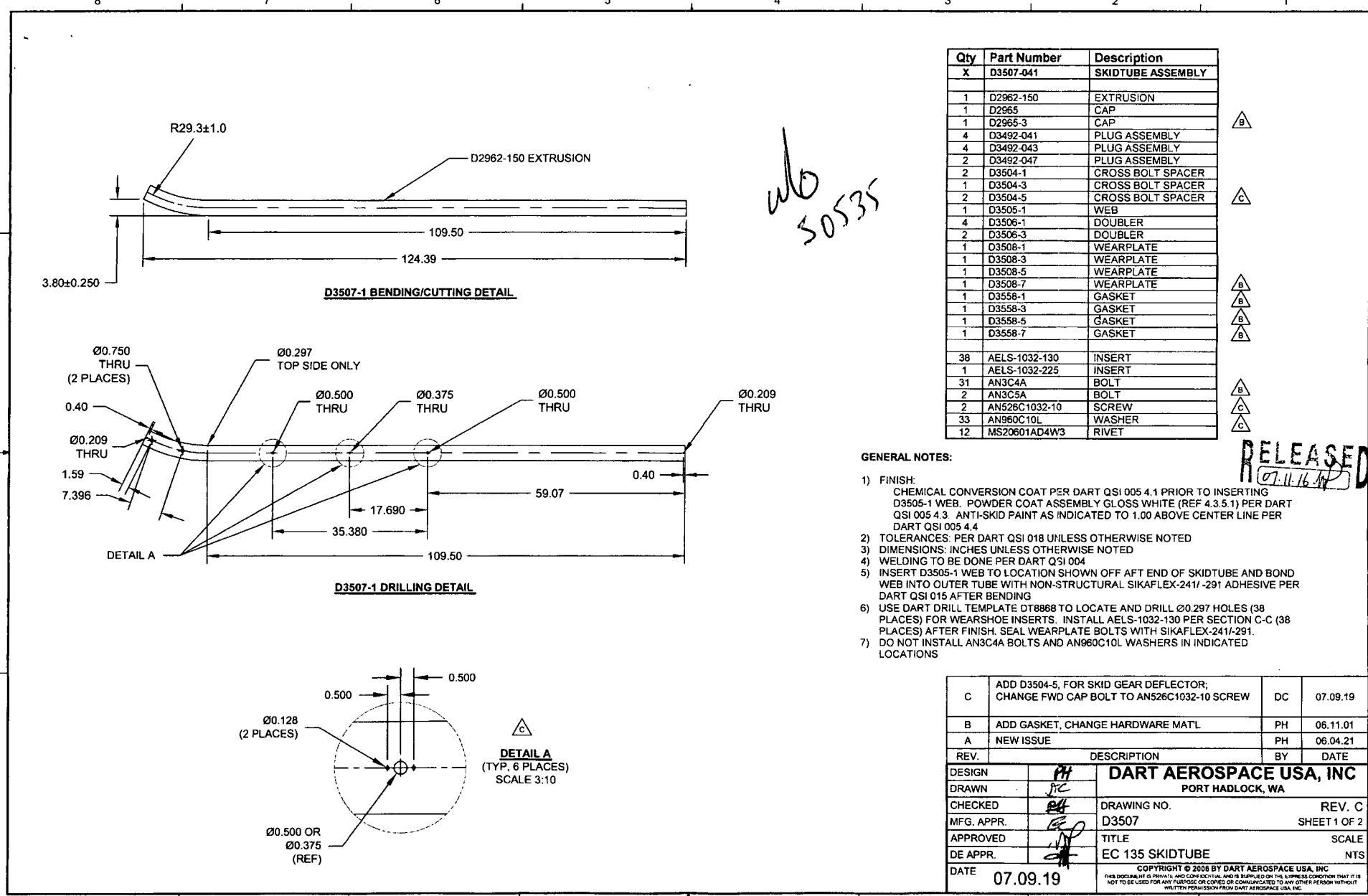
R
SV

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



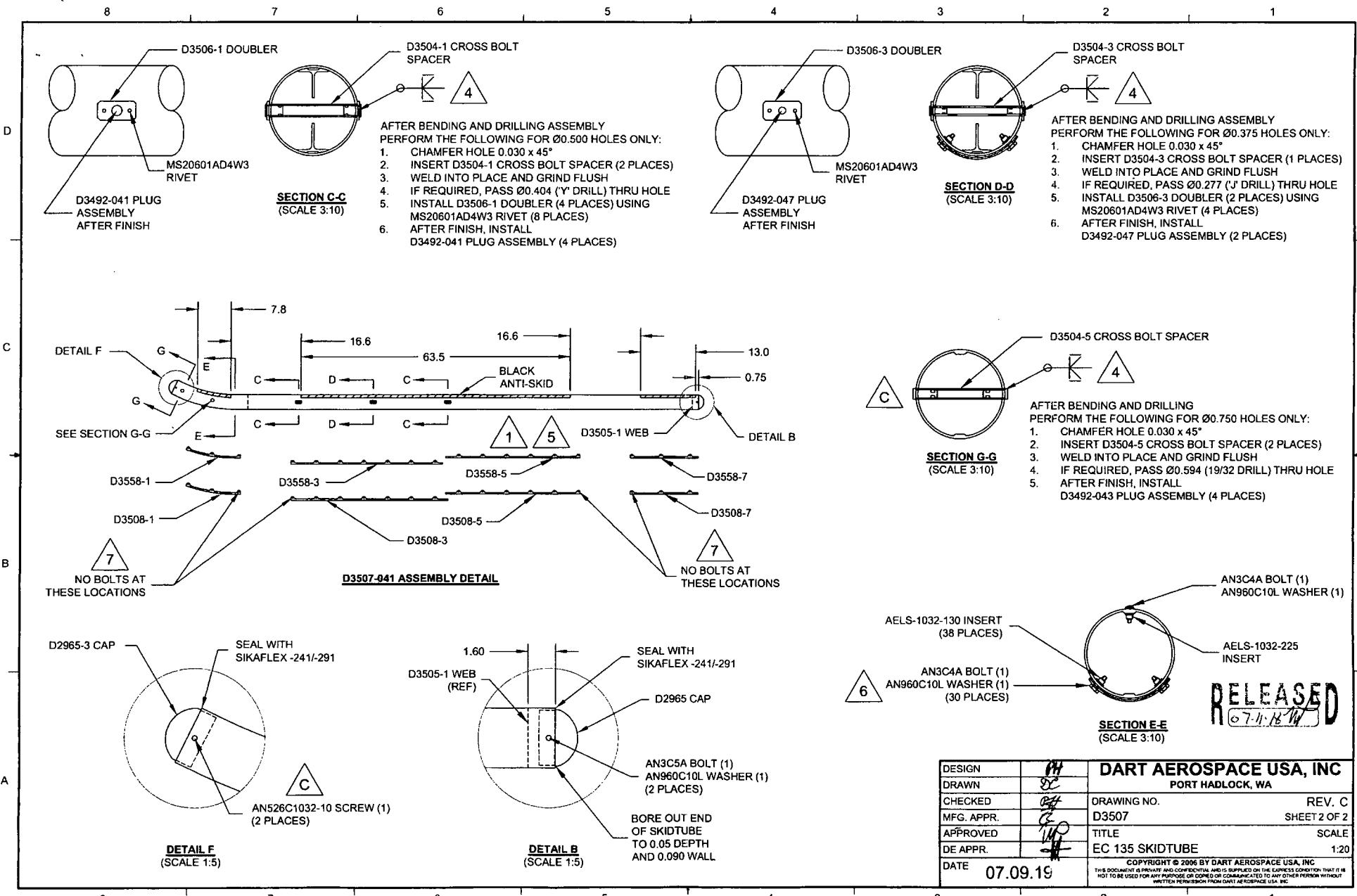
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/0 50535



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

19
NO. 204

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 505370
Part number: D135 751 011
Description: Skid tube
Welding Process: Tig Mig
Base material: Aluminum
Current: AC DC

TEST REQUIREMENTS AND RESULTS

Visual: pass fail
Penetration: pass fail

UNACCEPTABLE

Cracks: pass fail
Undercut: pass fail
Pin holes: pass fail
Overlap (cold lap): pass fail
Porosity (surface): pass fail
Coloration: pass fail

Qualifier Barclay Elliott Date of Test Coupon 09-07-16

Welder Barclay Elliott Date of Test Coupon 09/07/16

REFERENCE ONLY

The above named individual is qualified in accordance with AWS D17.1.2001 to weld